

# Work Order ID 83311

Tuesday, April 17, 2012 1:13:42 PM

**\*83311\***

Page 1

Item ID: D3235-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Mounting Lug  
 Start Date: 4/17/2012 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 4/25/2012 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 4-17-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3235	Rev A								

100 BAND SAW 0.00  
**\*100\***  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut D2423 extrusion to 0.820"  
 Batch: \_\_\_\_\_

*cut @ meter*

*CL 12/04/18*

110 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*110\***  
 HAAS 1 *Punch* Memo 0.00  
 HAAS CNC vertical machine #1 1-Machine as per Folio FA369 and Dwg D3235  
 2-Identify as D3235-1  
 3-Deburr

*issue 7/10 to meter*

*7/10:16747*

*CL 12/04/18 100*

120 QC2-Inspect parts off machine FAI/FAID 0.00  
**\*120\***  
 QC *recd.* Memo 0.00  
 Quality Control

*recd + inspect for transit damage  
 attached cufc to w/o*

*machine as per dwg D3235 Rev. A*

*4/12/10 100*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83311**

Tuesday, April 17, 2012 1:13:42 PM

**\*83311\***

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Item ID: D3235-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mounting Lug

Start Date: 4/17/2012 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

counted  
(97)

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

(97)

2/6/12-5-17

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*160\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:45

0.00

320°F

3:15

97 X

m/f

12/15/17

m12/134

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*83311\***

Page 3

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>						97	0		12/5/17
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>STV86</u>	0.00							
<b>*180*</b>						97			See 12/5/22
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									12/5/22
QC	Memo	0.00							
Quality Control									

mf  
12-05-22

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, April 17, 2012 1:13:46 PM

Work Order ID: 83311

\*83311\*

Parent Item: D3235-1

\*D3235-1\*

Parent Item Name: Mounting Lug

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A04.04.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-IP		Purchased	No			100	Each	0.0000	1	100			
*D3235-1P*									**				
lug													
D2423		Manufactured	No			110	f	273.1180	0.0683	7.189474			
*D2423*									**				
Lug Extrusion													

4/25/12 (100)

CL 2/10/18

Location	Loc Qty	Loc Code
MAT006	273.118	
43722	161.5	
45800	1	
68331	110.618	

81557

7.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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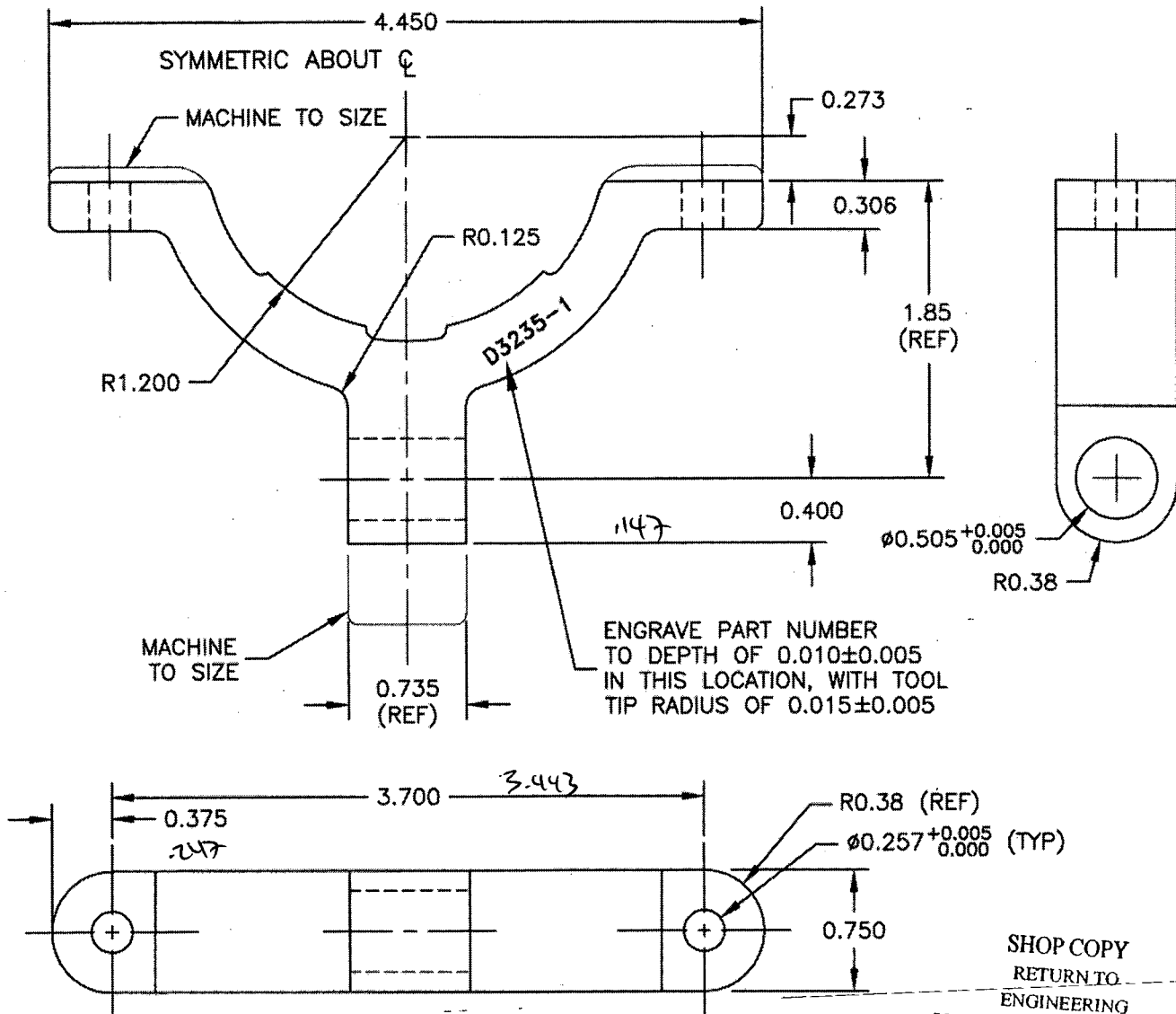
**NOTE:** Date & initial all entries



**DART**

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

**RELEASED**  
040405 *#*

**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83311

*R12-04-17*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16747

Purchase Order Date 4/18/12

PO Print Date 4/18/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, ON K0B 1R0  
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	5/04/12 Yes	160.00 Each	Dart Truck	\$18.9500	\$3,032.00
		Special Inst:	AS PER DWG D2230 REV. G B83273				
2	D2230-3P	LUG	5/04/12 Yes	160.00 Each	Dart Truck	\$13.6000	\$2,176.00
		Special Inst:	AS PER DWG D2230 REV. G B83261				
3	D3235-1P	lug	5/04/12 Yes	100.00 Each	Dart Truck	\$15.0500	\$1,505.00
		Special Inst:	AS PER DWG D3235 REV. A B83311				

PO Total: \$6,713.00

Change Nbr: 1

Change Date: 4/18/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



**Invoice No.:** 9092  
**Date:** Apr 27, 2012  
**Page:** 1

**Dart Aerospace Ltd.**  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario K6A 1K7

**Shipping Address**  
 Dart Aerospace Ltd.  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario K6A 1K7

P.O. Number 16747		Shipped by your truck    Delivery Slip #: 18667		Terms: 2%/10, Net 30. Due May 27, 2012.			
Description		Quantity ordered	Quantity shipped	Quantity on B/O	Unit	Unit Price	Amount
D2230-1    Mounting Lug		160		110	Each	18.95	
D2230-3    Mounting Lug		160			Each	13.60	
D3235-1    Mounting Lug (Delivery slip quantity showed 100 pieces, but actual quantity shipped was 97 pieces)		100	97		Each	15.05	1,459.85
H - HST 13% HST							189.78
Thank you for your order!							
HST # 867 061 723 RT0001 Interest on overdue accounts is charged at 24% per year		Total in CAD				1,649.63	

METEC Metal Technology Inc. 20 Terry Fox Drive P.O. Box 781 Vankleek Hill ON K0B 1R0 Canada  
 Tel. 1-613-678-3957 & 1-613-678-2782 Fax 1-613-678-3956 www.metec.ca



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

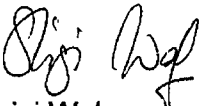
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
97	D3235-1	Lug	16747

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, April 27, 2012